

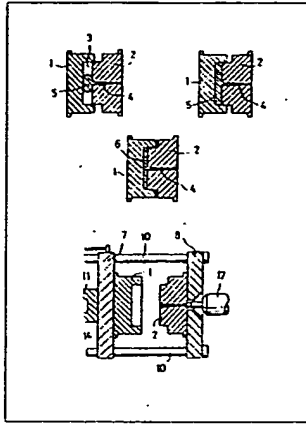
===== WPI =====

- TI - Injection moulding of disc-shaped recording medium - by forming a cavity, injection filling with molten resin, moving the mobile mould, exerting pressure on mould and cooling
- AB - J63027219 In a method of injection moulding a disc-shaped recording medium, a cavity, forming a disc-shaped recording medium, e.g. video- or compact-disc, is variably formed with fixed- and moving-moulds which are engaged with each other; so that the vol. of the cavity is large, injection filling with molten resin is started; when a filling amt. is increased to a given amt. which is not sufficient to fill the cavity, the moving mould is moved at a given speed so as to continue the filling, and a decrease in the vol. of the cavity is started; after injection filling is stopped right before the cavity is completely filled with molten resin, a given pressure is exerted on the moving mould to perform complete filling with the molten resin and control of the pressure: and cooling is held under the pressure.
- USE/ADVANTAGE - Improves fluidity available during injection process when injection is started, and can execute high speed low pressure filling, resulting in improvement of transfer properties by which strain due to internal stress is prevented from prodn..
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- JP3066129B B 19911016 DW199145 000pp
- PR - JP19860170593 19860719
- PA - (NSSK) NISSEI JUSHI KOGYO KK
- MC - A11-B12A A12-W01 A12-W01A
- T03-B01A T03-N01 W04-C01
- DC - A32 T03 W04
- IC - B29C45/00 ;B29K69/00 ;B29L11/00 ;B29L17/00 ;G11B7/26
- AN - 1988-073805 [25]

===== PAJ =====

- TI - INJECTION MOLDING METHOD FOR DISKLIKE RECORDING MEDIUM
- AB - PURPOSE: To contrive an improvement in transfer properties and a reduction in orientation of resin, by a method wherein when a filling quantity of molten resin arrives at a necessary quantity which does not come to fill out a cavity, a movable mold is moved at a necessary speed while injection filling is kept continuing, the injection filling is suspended directly before the complete injection filling and pressurization is performed.
- CONSTITUTION: A movable mold 1 and stationary mold 2 which are in a state of mold break are clamped together by a movement of a movable platen 7 at a high speed. It is preferable that a depth of a cavity 3 to be formed through the mold clamping is less than 3 times as thick as a thickness of a molded product. When a cavity 3 of predetermined capacity is formed, the cavity 3 is filled with molten resin 5 through injection by suspending the movable platen 7. Then when the molten resin 5 arrives at a predetermined filling quantity (40-80%) which is prior to filling of the cavity 3, the movable mold 1 is moved in the direction of the stationary mold 2 by moving forward the movable platen 7 again without suspending injection filling and the filling of the molten resin 5 is suspended directly before the complete filling of the same. Then pressure is applied to the movable mold 1, the molten resin 5 is pressurized and compressed, transfer properties are improve and a disklike recording medium 6 wherein orientation properties have been reduced is molded.
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- PA - NISSEI PLASTICS IND CO
- IN - MIYAHARA MASAOKI; others: 01
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